

Sup 27/04

Work Order ID 68598



Monday, April 18, 2011 11:15:12 AM

Item ID:	D3724-042	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Step Assembly					
Start Date:	4/18/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	4/26/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	Tooling:		Date:		Run	Start	
	QC:		Date:	SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3724	Rev B								
100	Large Fab	0.00							
	Large Fab	0.00							
Large Fab	Memo								
	1-Cut D3737-2 as per dwg D3737								
	2-Cut D3738-2 as per dwg D3738								
	3-Deburr and bevel ends for welding								
110	QC- Inspect part completeness to step on W/O	0.00							
	QC	0.00							
Quality Control	Memo								

Pl 11-04-19

1 0

Pl 11-04-19

710

W/O: 68598		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11-04-19	110	CHANGE TO QC 6	MA	11.04.27			S 11/04/19

Part No: D3724-042 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68598

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Monday, April 18, 2011 11:15:12 AM

Item ID: D3724-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Assembly

Start Date: 4/18/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/26/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

Weld per dwg A/R Aluminum rod Batch: 114703
Large Fab 115938 0.00

Large Fab

Memo

0.00

Large Fab

1-Weld D3738-1, D3737-1 and D3733-1 as per dwg D3724

2-Grind flush

11.04.19 1 0

130

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

1 0 BE 11/04/19

140

Chemical Conversion Coat per QSI005 4.1 0.00



HandFinish

Memo

0.00

Hand Finishing

11.04.19 1 0

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00

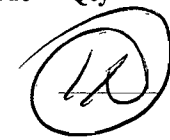


QC

Memo

0.00

⇒ m-l 11/04/11



Quality Control

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 4/26/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.00



Large Fab

Large Fab

Memo

0.00

1-Apply Magnabond before installing rivets

A/R Magnabond 6398 Batch: M114158

2-Rivet D3741-1 and D3730-1 to brackets before installing on step as per dwg D3724

3-Transfer holes from D3730-1 and D3741-1 into step as per dwg D3724

4-Deburr

5-Apply magnabond as per dwg D3724

A/R Magnabond 6398 Batch: M114158

6-Rivet brackets in place on step as per dwg D3724

7-Weld both end cap as per Dwg D3724

8-Grind end cap welds flush

Inspect for foreign object per QSI 024

11.04.25

W/O:		WORK ORDER CHANGES					
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Reference:						

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	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M 116964</i> Memo START TIME: <i>11:20</i> OVEN TEMPERATURE: <i>3200</i> FINISH TIME: <i>11:30</i>	0.00 0.00				<i>1</i>	<i>OK</i>	<i>11-4-26</i>	
210 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>1</i>	<i>OK</i>	<i>11-4-26</i>	
220 HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <i>M 1173150</i> Memo	0.00				<i>1</i>	<i>OK</i>	<i>11-4-26</i>	

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Cust Item ID:

Required Date: 4/26/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230 QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Dulcor

240 Identify as per dwg & Stock Location: _____ 0.00



Packaging

Memo

0.00

Packaging

*PP68598**4/18/27 C*

250 QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

*11/4/27 J**MF 11-04-27*

Picklist Print

Monday, April 18, 2011 11:15:09 AM

Page 1

Work Order ID: 68598

Parent Item: D3724-042

Parent Item Name: Step Assembly

Start Date: 4/18/2011


Required Date: 4/26/2011

Start Qty: 1.00


Required Qty: 1.00

Comments: IPP Rev:A new issue 08-02-07 DD verified by:ec
IPP Rev:B ecn 1154p 08-03-13 DD verified by:ec
IPP Rev:C ecn 1158 08-03-19 DD verified by:


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

CR3213-5-4  Cherry Rivet		Purchased	No			160	Each	54.0000	32	32		11.04.25	
---	--	-----------	----	--	--	-----	------	---------	----	----	--	----------	--

Location	Loc Qty	Loc Code
WA018	54	
114100	54	

D2622-120C  Step Extrusion		Manufactured	No			100	Each	149.0000	1	1		11.04.19	
---	--	--------------	----	--	--	-----	------	----------	---	---	--	----------	--

Location	Loc Qty	Loc Code
HALL	20	
64409	20	
WA	129	
46910	2	
64409	1	
66970	126	

D2734  Step End Plate		Manufactured	No			160	Each	73.0000	2	2		11.04.25	
--	--	--------------	----	--	--	-----	------	---------	---	---	--	----------	--

Location	Loc Qty	Loc Code
WA015	73	
66143	73	

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Monday, April 18, 2011 11:15:09 AM

Page 2

Work Order ID: 68598



Parent Item: D3724-042



Parent Item Name: Step Assembly

Start Date: 4/18/2011

Required Date: 4/26/2011

Start Qty: 1.00

Required Qty: 1.00

D3728-1
Step Bracket
Manufactured No

160 Each

6.0000

3

3



11.04.19

Location

Loc Qty

Loc Code

WA013

6

38223

3

56589

3

3

D3729-1
Step Bracket
Manufactured No

160 Each

3.0000

1

1



11.04.19

Location

Loc Qty

Loc Code

WA013

3

38468

3

1

D3730-1
Angle
Manufactured No

160 Each

3.0000

8

8



11.04.22

Location

Loc Qty

Loc Code

WA013

3

B68596

56652

3

5

3

D3733-1
Gusset
Manufactured No

120 Each

18.0000

1

1



11.04.19

Location

Loc Qty

Loc Code

WA002

18

38469

18

1

D3741-1
Angle
Manufactured No

160 Each

4.0000

8

8



11.04.19

Location

Loc Qty

Loc Code

WA013

4

B68597

56651

4

4

4

Monday, April 18, 2011 11:15:09 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Picklist Print

Monday, April 18, 2011 11:15:09 AM

Page 3

Work Order ID: 68598

Parent Item: D3724-042

Parent Item Name: Step Assembly

Start Date: 4/18/2011

Required Date: 4/26/2011

Start Qty: 1.00

Required Qty: 1.00

MS20470AD5-11

Purchased

No

160

Each

1,090.000

12

12



Rivet



SAD 11-04-22

Location

Loc Qty

Loc Code

ST321

1090

107100

1090

12

MS20470AD5-16

Purchased

No

160

Each

792.0000

4

4



Rivet



SAD 11-04-22

Location

Loc Qty

Loc Code

ST321

792

107100 *

792

4

Monday, April 18, 2011 11:15:10 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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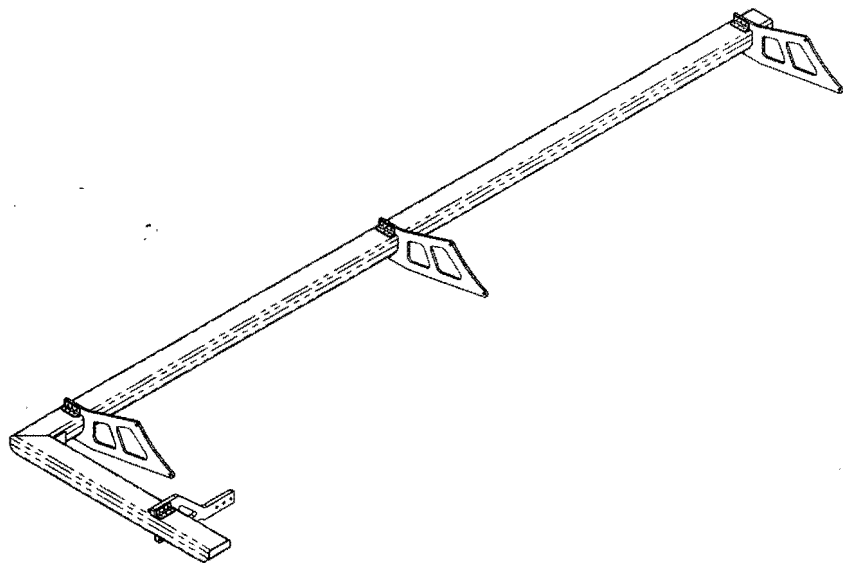
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____


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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3724-042 STEP ASSY (SHOWN)
D3724-041 STEP ASSY (OPPOSITE) 

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3724-041	STEP ASSEMBLY
	X	D3724-042	STEP ASSEMBLY
2	2	D2734-1	END PLATE
8	8	D3730-1	ANGLE
1	1	D3733-1	GUSSET
1		D3737-1	STEP
	1	D3737-2	STEP
1		D3738-1	STEP
	1	D3738-2	STEP
1	1	D3747-1	DECAL
32	32	CR3216-5-4	RIVET
12	12	MS20470AD5-11	RIVET
4	4	MS20470AD5-16	RIVET
8	8	D3741-1	ANGLE
3	3	D3728-1	STEP BRACKET
1	1	D3729-1	STEP BRACKET

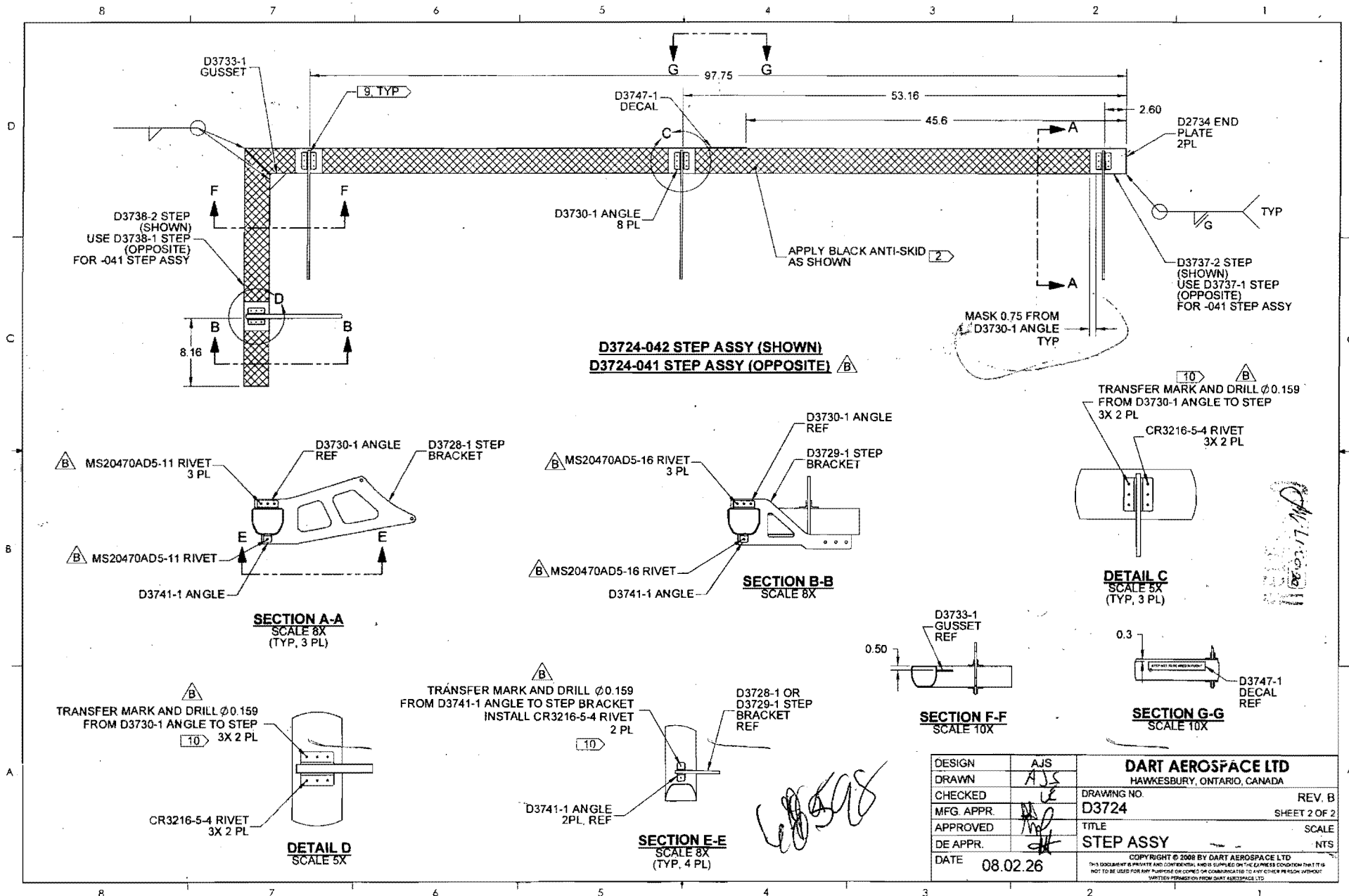
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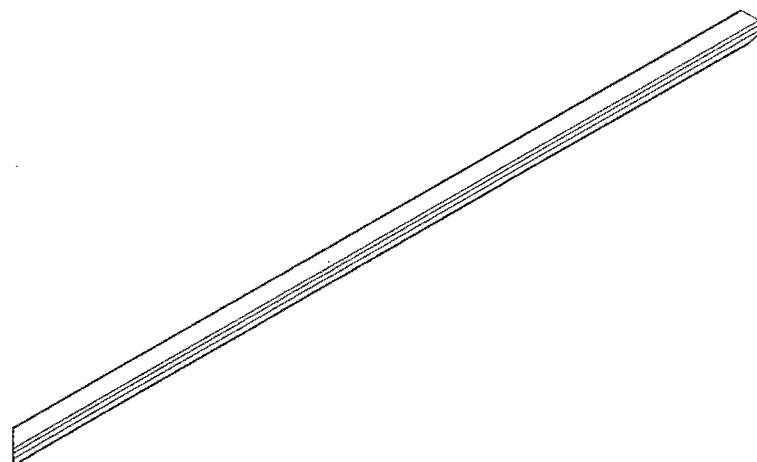
- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT WELDMENT PER DART QSI 005 4.1 PRIOR TO ASSEMBLY
POWDER COAT ENTIRE ASSEMBLY WHITE GLOSS (4.3.5.1) PER DART-QSI 005 4.3
APPLY BLACK ANTI-SKID PER DART QSI 005 4.4 WHERE INDICATED
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 13.89 lbs
- 8) WELDING: PER DART QSI 004
- 9) APPLY MAGNOBOND 6398 BETWEEN MATING SURFACES WHERE INDICATED
- 10) TOUCH UP CHEMICAL CONVERSION COAT ON ALL PARTS TRANSFER-DRILLED. (REF QSI 005 4.1)

68598

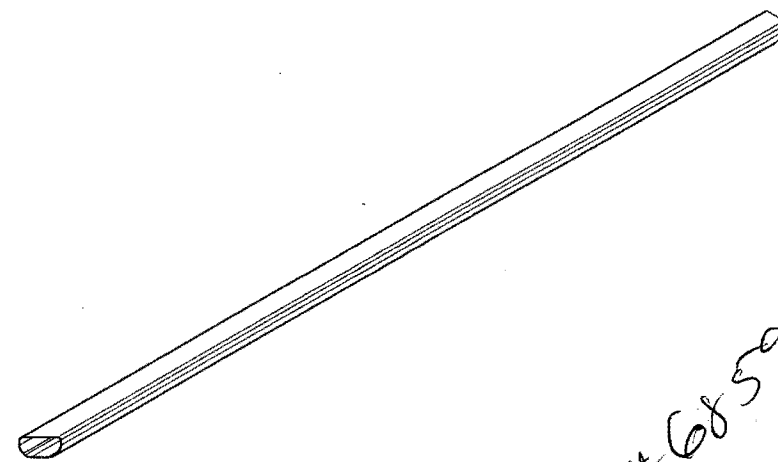
11-08-01-17-10-10

B	ADD -041 ASSEMBLY. ADD D3747-1 DECAL TO P/L SHEET 2 TRANSFER MARKING INSTRUCTIONS FOR INSTALLING D3730-1 & D3741-1 ON D3728-1 & D3729-1 DELETED. SHEET 2 DETAIL C, D & SECTION E-E Ø0.159 WAS Ø0.098. ZONE D4 53.15 DIM WAS 53.22, 2.60 DIM WAS 2.66. ADD SECTION G-G.	AJS	08.02.26
A	NEW ISSUE	AJS	08.02.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS	DRAWING NO.	REV. B
CHECKED	LE	D3724	SHEET 1 OF 2
MFG. APPR.	MP	TITLE	SCALE
APPROVED	MP	STEP ASSY	NTS
DE APPR.		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.02.26		





D3737-1 STEP



D3737-2 STEP 

#68598

08-02-17-11-10

NOTES:

- 1) MATERIAL: MAKE FROM D2622-106 EXTRUSION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 7.67 lbs

B	ADDED SHEET 3, -2 WAS -1; ADDED NEW -1.	AJS	08.03.06
A	NEW ISSUE	AJS	08.02.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ALS		
CHECKED	ME	DRAWING NO.	REV. B
MFG. APPR.	ME	D3737	SHEET 1 OF 3
APPROVED	ME	TITLE	SCALE
DE APPR.	#	STEP	NTS
DATE	08.03.06	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

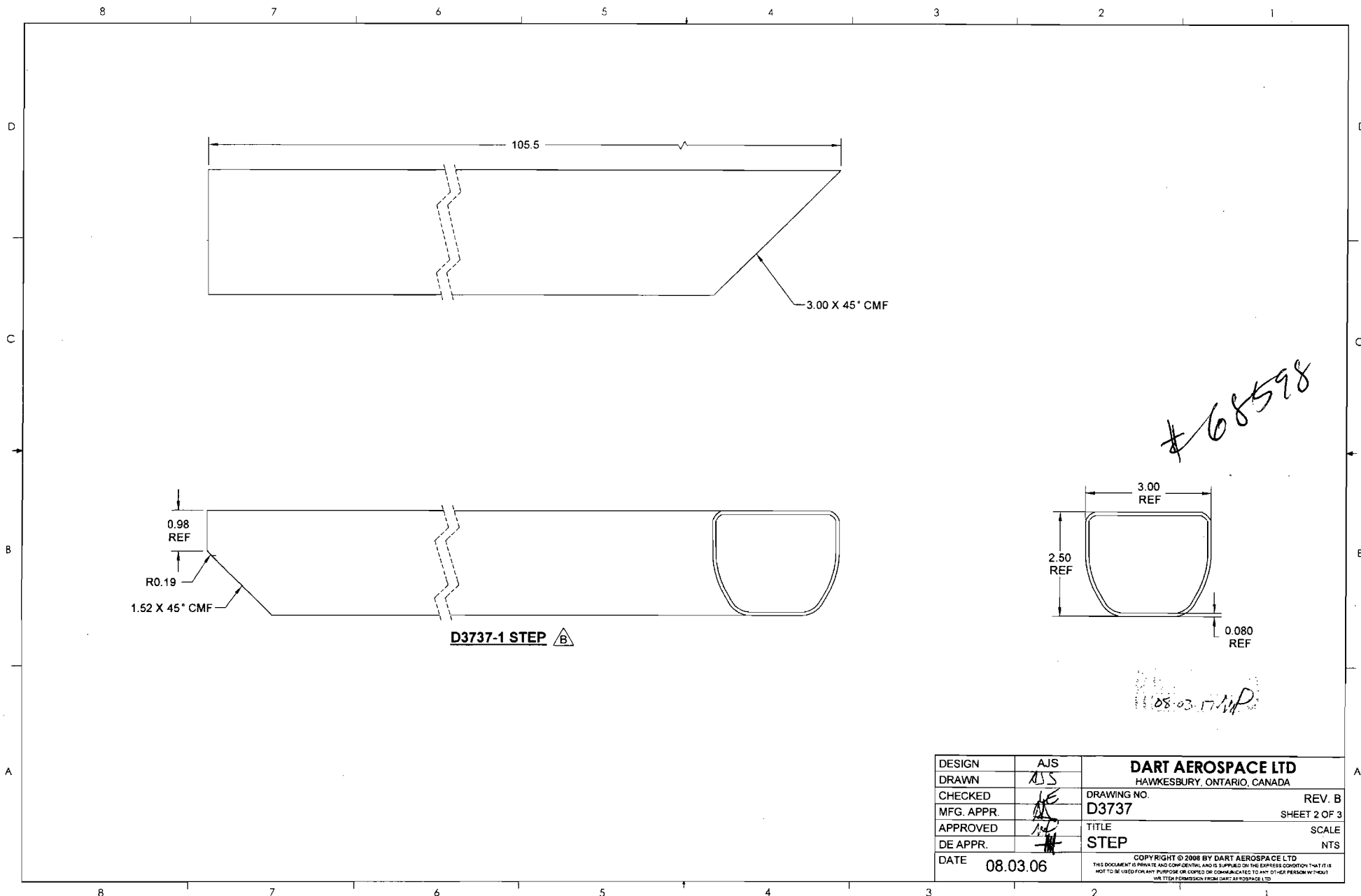
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DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3737	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	STEP	NTS
DATE	08.03.06	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

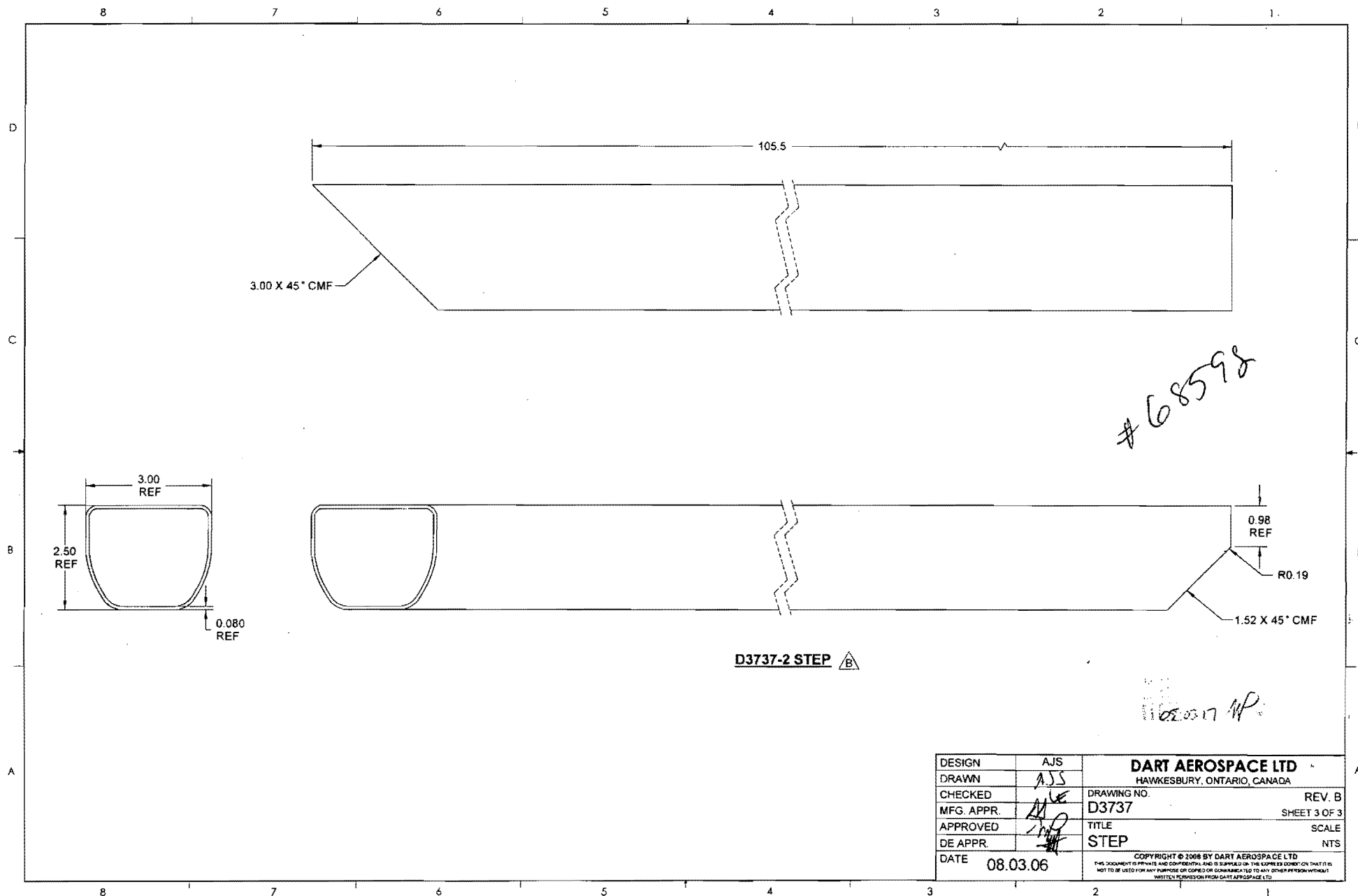
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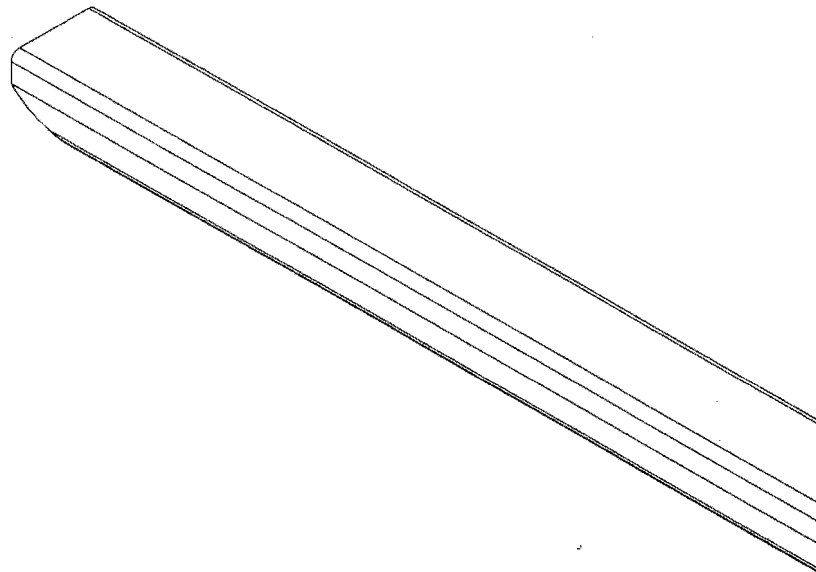
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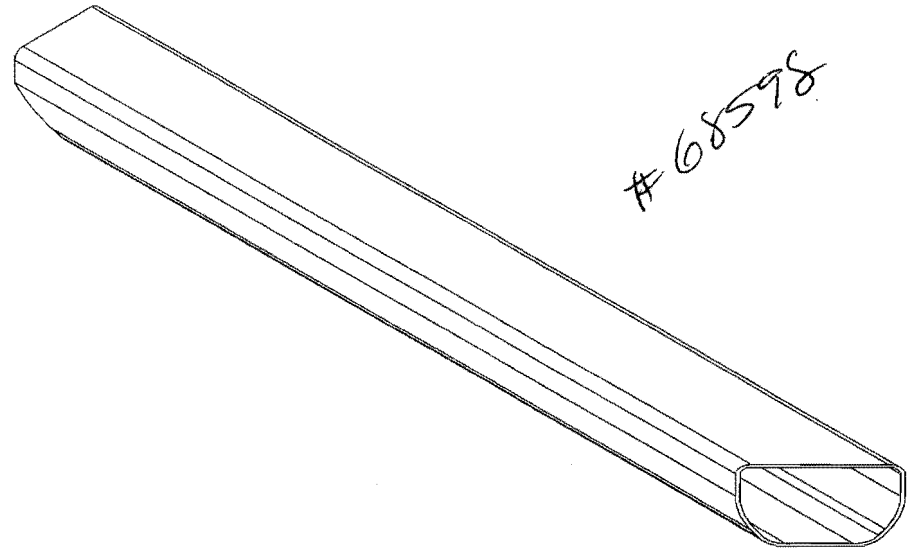
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			


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8 7 6 5 4 3 2 1



D3738-1 STEP



D3738-2 STEP 

#68598

11080317.11/18

- NOTES:
- 1) MATERIAL: MAKE FROM D2622-29 EXTRUSION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.96 lbs

B	ADDED SHEET 3 -2 WAS -1; ADDED NEW -1.	AJS	08.03.06
A	NEW ISSUE	AJS	08.02.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ASS		
CHECKED	KE		
MFG APPR	MP		
APPROVED	MP		
DE APPR	MP	DRAWING NO. D3738 REV. B TITLE STEP SCALE NTS	
DATE	08.03.06	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

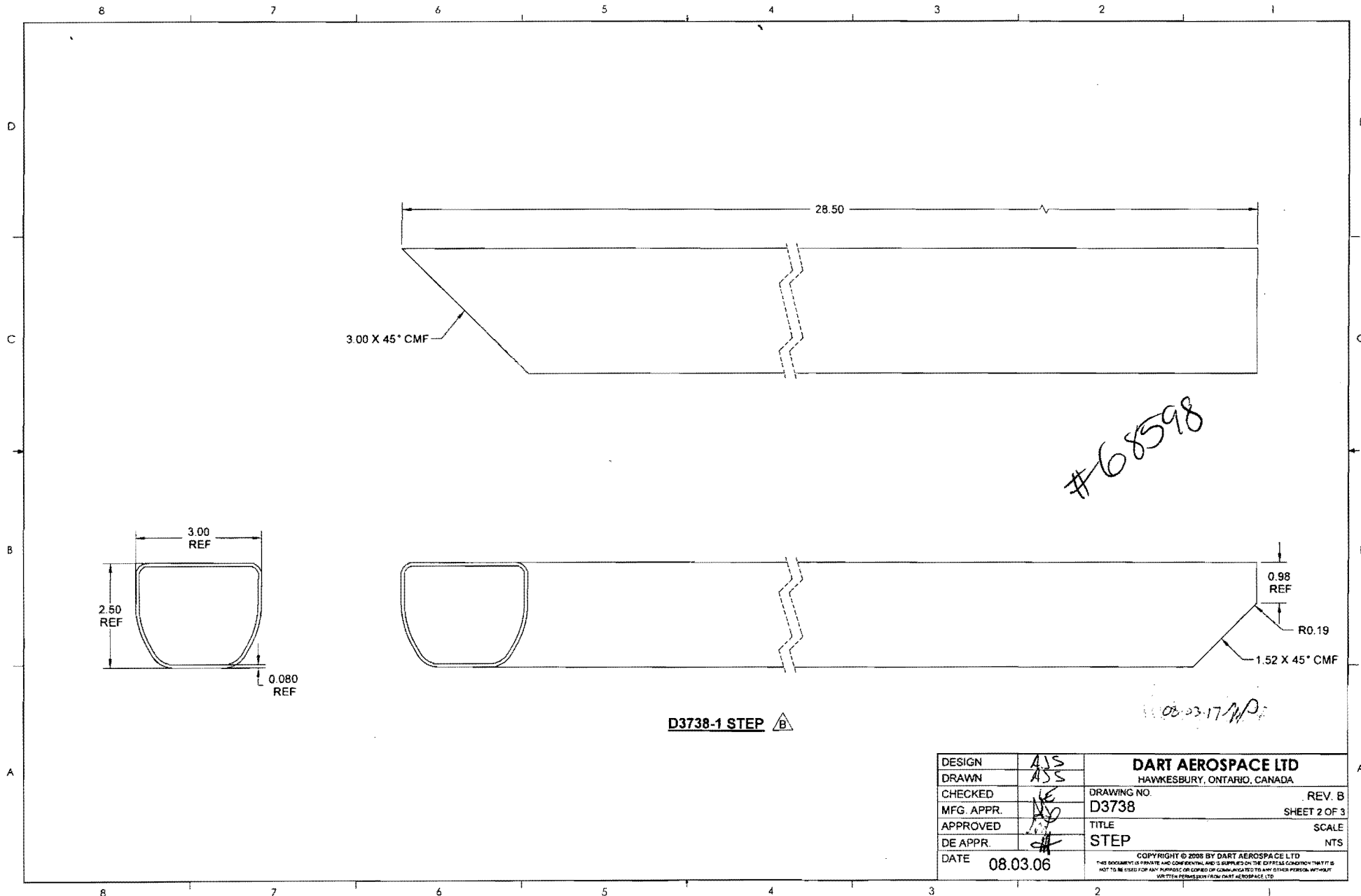
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



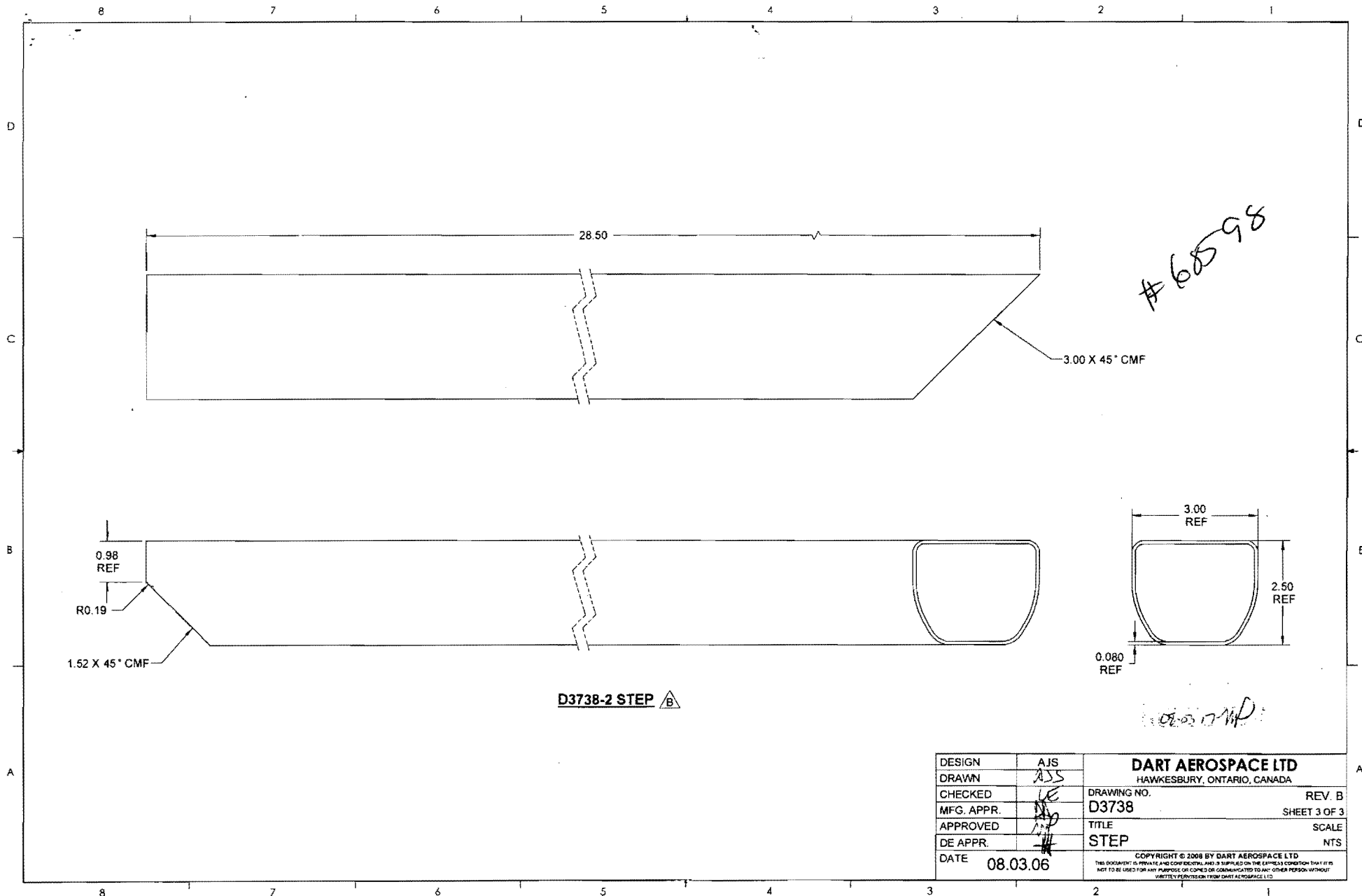
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries